

Date: Monday, 10/22/2007 3:57:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ASPIRATOR ASS'Y
Job Number	: 35293		
Estimate Number	: 11909		
P.O. Number	:	Part Number	: D2000047
This Issue	: 10/22/2007 S.O. No. :	Drawing Number	: D2000047 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: A1
Previous Run	: 27295	Material	:
Written By	:	Due Date	: 12/10/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>10/27/07</u>		
Comment	: Est. C 02.03.05 Revised Pick List SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2714	Washer
-----	-------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	D2714	Washer	18164

10 50

2.0	D2000043	Jet
-----	----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Jet

Pick:

Qty	Part Number	Description	Batch
1	D2000-043	Jet	040579

PD 03-00-14

3.0	D2000109	Aspirator- Outer Flange
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aspirator- Outer Flange

Pick:

Qty	Part Number	Description	Batch
1	D2000-109	Aspirator	35321

10 50

4.0	D2000111	Aspirator - Inner Core
-----	----------	------------------------



(4x)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aspirator - Inner Core

Pick:

Qty	Part Number	Description	Batch
1	D2000-111	Aspirator	35322

8/1/21 28/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:57:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASS'Y

Job Number: 35293

Part Number: D2000047

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30471

Screen Vent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screen Vent

Pick:

Qty Part Number Description Batch

1 D3047-1

Screen

17361

Rec'd 22 (8)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble jet D2000-043 in aspirator D2000-109 per dwg D2000

Weld jet D2000-043 in aspirator D2000-109 per dwg D2000

D 08-08-14 (8)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

108/08/15 (8)

8.0

OUTSIDE SERV.15

OUTSIDE SERVICES - LF



Comment: Sub-Contracting HAND FINISHING RESOURCE #1

Anodize Matte Black per QSI 017

R/O: 6956 C 208/08/15

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Rec'd 28 (8)

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Socolor (8)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble screen & washer as per dwg D2000

FF 08/09/10

(8)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Socolor (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASS'Y

Job Number: 35293

Part Number: D2000047

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



(8x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 110

8/9/11

SP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/11 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



12 08/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

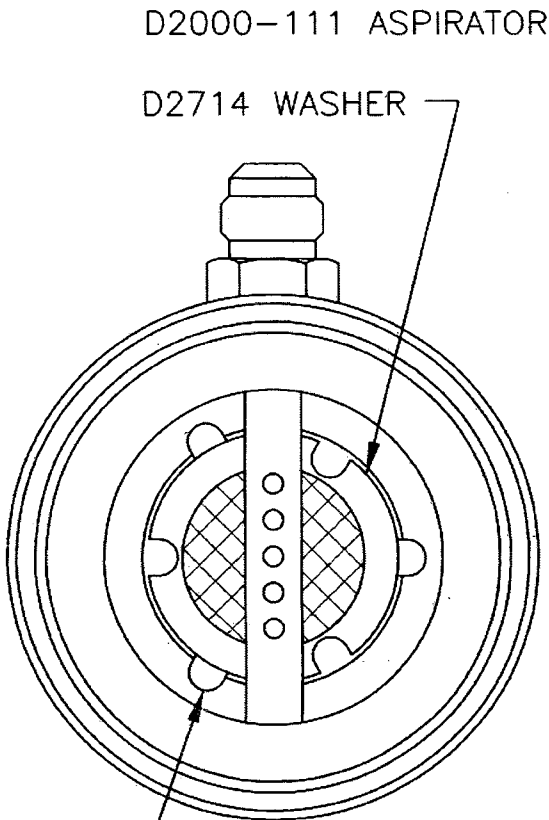
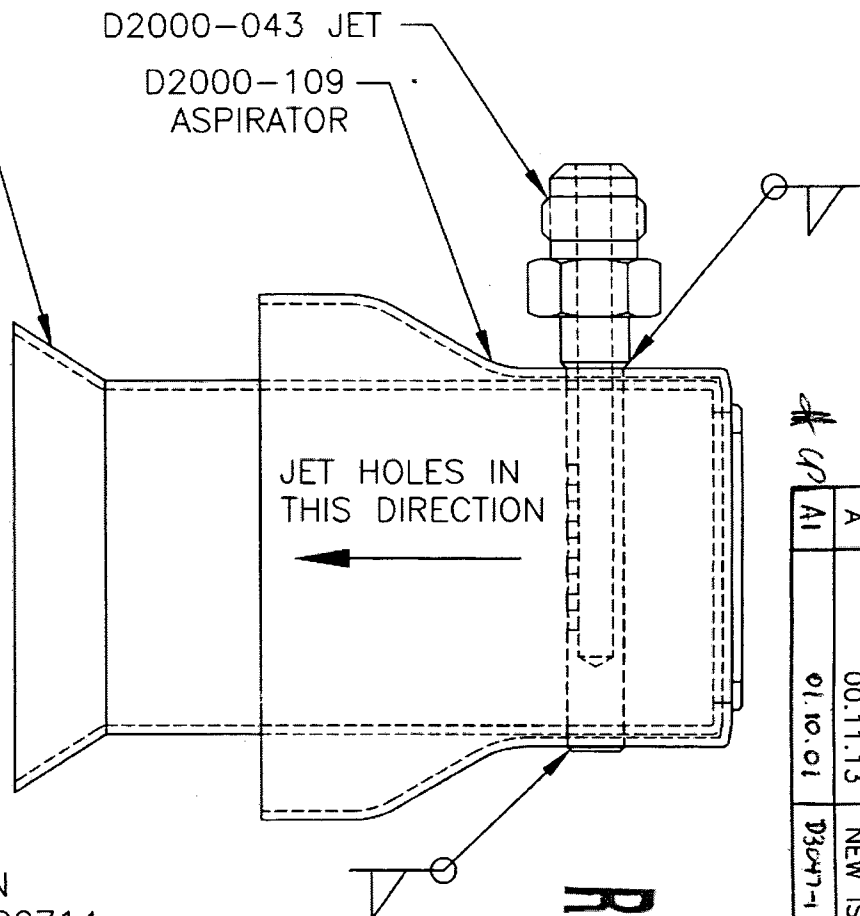
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO.	SHEET 1 OF 1
00.11.13		D2000-047	
		TITLE	SCALE
		ASPIRATOR ASSEMBLY	1:1
A	00.11.13	NEW ISSUE	
A1	01.10.01	D3047-1 W4S XS-51162,K1210	



D3047-1
~~XS-51162,K1210~~ SCREEN
BEND 3 TABS TO HOLD D2714
WASHER. INSTALL IN ASPIRATOR AND
BEND REMAINING THREE TABS TO HOLD
IN PLACE AS SHOWN

NOTES:

WELD PER DART QSI 004

FINISH: ANODIZE MATTE BLACK PER MIL-A-8625F TYPE I OR IB OR IC
OR II OR IIB CLASS 2INSTALL ~~XS-51162,K1210~~ SCREEN AND D2714 WASHER AFTER FINISH**RELEASED**
00.11.20

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UNCONTROLLED COPY
ENGINEERING
RETURN TO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
33243

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved

67430

25-Aug-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

NO. DE COMMANDE: 6956
PURCHASE ORDER/



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	7	7	D2091 B30137	
2	8	8	D2000-047 B35293	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
3	10	10	D2224 B40891	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
				BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

Signature
08/08/09

Vous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

